

Date: Thursday, 2/23/2006 10:17:00 AM  
User: Kim Johnston

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE FITTING, FWD (OUTBOARD/INBOARD)	
<b>Job Number</b> :	25898	<b>Part Number</b> :	D2572	
<b>Estimate Number</b> :	10531	<b>Drawing Number</b> :	D2572 REV E	
<b>P.O. Number</b> :	N/A	<b>Project Number</b> :	N/A	
<b>This Issue</b> :	2/23/2006	<b>Drawing Revision</b> :	E	
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	N/A	
<b>First Issue</b> :	N/A	<b>Due Date</b> :	3/15/2006	<b>Qty:</b> 7 <b>Um:</b> Each
<b>Previous Run</b> :	25860	<b>Type</b> :	MACHINED PARTS	
<b>Written By</b> :	See Comment Below			
<b>Checked &amp; Approved By</b> :	06.02.23			
<b>Comment</b> :	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ			

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
7075-T7351 8.25X5.0X2.5  
Make from D6101-005 billet for D2572  
Ensure that grain is along 5.00" length  
Batch No: 3 24069 x 6

7

06/03/23

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
Program Batch No. 325878 Double check by: ml

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove shap edges.

EP/S.G. 06/03/25

7

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2571 & D2572

EP/S.G. 06/03/25

7

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   *LD*   Date:   06/03/30  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 2/23/2006 10:17:00 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25898

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



7

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W J.G. 06/03/25

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 06/03/28 7

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-03-28 (7)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/03/28 (7)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

6/3/29 (7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 429

6/3/29 (7)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/03/30 (7)

Job Completion



W 06/03/29

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>25898</b>
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	<b>D2572</b>
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.747	1.747	1.747	1.747		
C	3.495	3.505		3.500	3.500	3.497	3.497		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		8.004	8.003	8.003	8.003		
F	0.490	0.510		0.501	0.500	0.500	0.500		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.499	0.494	0.495		
J	1.174	1.184		1.177	1.177	1.178	1.178		
K	0.558	0.578		0.569	0.568	0.564	0.565		
L	1.174	1.184		1.176	1.178	1.178	1.178		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.498	2.499	2.496	2.495		
O	3.869	3.879		3.883	3.874	3.872	3.872		
P	0.115	0.135		0.127	0.126	0.128	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.249	0.249	0.247	0.247		
S	0.115	0.135		0.122	0.124	0.122	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.961	2.959	2.958		
V	0.230	0.250		0.240	0.241	0.236	0.236		
W	0.115	0.135		0.131	0.130	0.127	0.127		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.360	0.361	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.627	0.621	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.248	0.245	0.246		
AE	1.375	1.395		1.385	1.389	1.387	1.387		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.244	0.244	0.248	0.248		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	J.G
Date:	06/03/25

Audited by:	M
Date:	06/03/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>25898</b>
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E	7.990	8.010		8.004	8.004	8.004			
F	0.490	0.510		0.500	0.501	0.499			
G	0.257	0.262	DT8683	0.257	0.257	0.257	<del>0.257</del>		
H	0.375	0.380	DT8684	0.375	0.375	0.375	<del>0.375</del>		
I	0.490	0.510		0.498	0.498	0.495			
J	1.174	1.184		1.177	1.177	1.179			
K	0.558	0.578		0.568	0.567	0.567			
L	1.174	1.184		1.177	1.177	1.179			
M	1.490	1.500		1.494	1.495	1.497			
N	2.495	2.505		2.499	2.498	2.497			
O	3.869	3.879		3.872	3.873	3.871			
P	0.115	0.135		0.127	0.128	0.126			
Q	0.115	0.135		0.130	0.130	0.130	<del>0.130</del>		
R	0.240	0.260		0.249	0.248	0.248			
S	0.115	0.135		0.125	0.127	0.123			
T	0.178	0.198		0.188	0.188	0.188	<del>0.188</del>		
U	2.940	2.980		2.961	2.960	2.959			
V	0.230	0.250		0.244	0.243	0.234			
W	0.115	0.135		0.127	0.128	0.127			
X	0.307	0.312		0.310	0.310	0.310	<del>0.310</del>		
Y	0.760	0.765		0.760	0.760	0.760	<del>0.760</del>		
Z	0.352	0.372		0.362	0.360	0.361			
AA	0.470	0.530		0.500	0.500	0.500	<del>0.500</del>		
AB	0.615	0.635		0.624	0.623	0.625			
AC	0.053	0.073		0.063	0.063	0.063			
AD	0.240	0.260		0.245	0.244	0.251			
AE	1.375	1.395		1.388	1.389	1.388			
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AI	2.000	2.020		N/A	N/A	N/A			
AJ	0.023	0.043		0.030	0.030	0.030			
Accept/Reject									

Measured by:	J.G.
Date:	06/03/27

Audited by:	J.M.
Date:	06/03/28

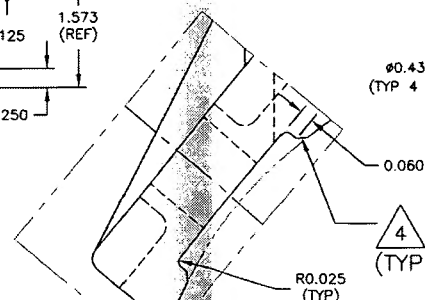
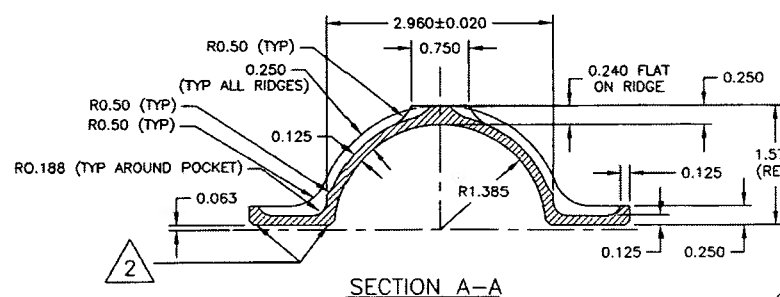
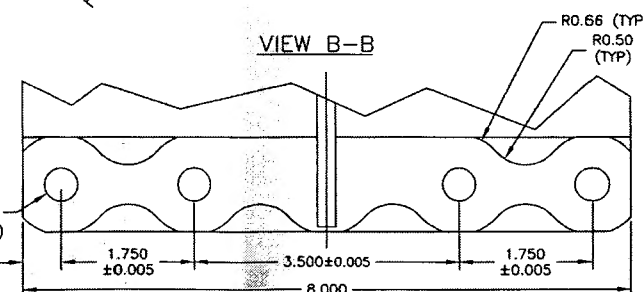
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C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06



MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN

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**DART**

**DART AEROSPACE LTD.**  
MARKHAM, ONTARIO, CANADA

<div style="border: 1px solid black; padding: 2px; width: 100px; float: left; margin-right: 10px;">CHECK</div> <div style="clear: both;"></div>
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APPROVED

DRAWING NO.	D2572
-------------	-------

DATE \_\_\_\_\_

02072	
TITLE	
INNER FWD SADDLE	

REV. E

SCALE

2:3

DETAIL C  
SCALE 2:1

SHOP COPY  
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